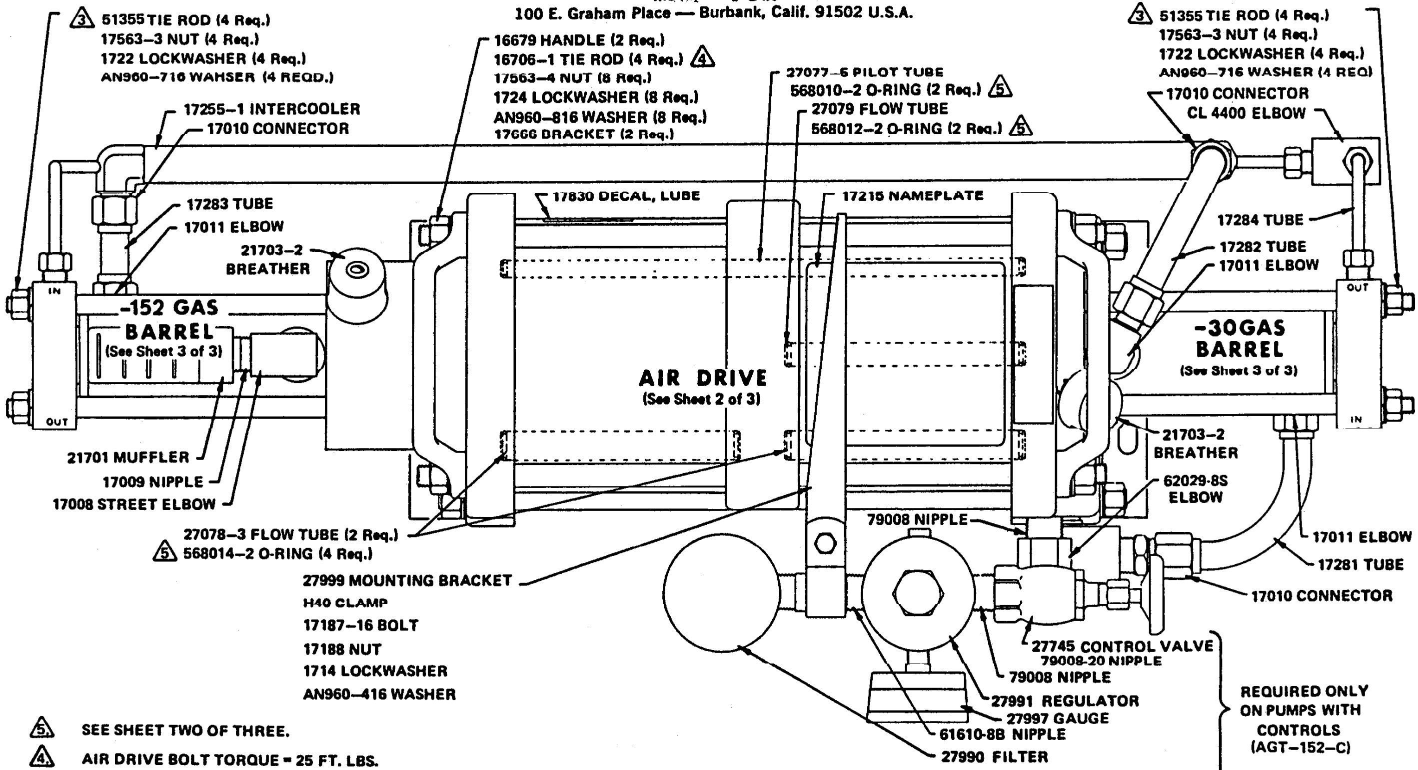
Haskel INCORPORATED

100 E. Graham Place — Burbank, Calif. 91502 U.S.A.



NOTES:

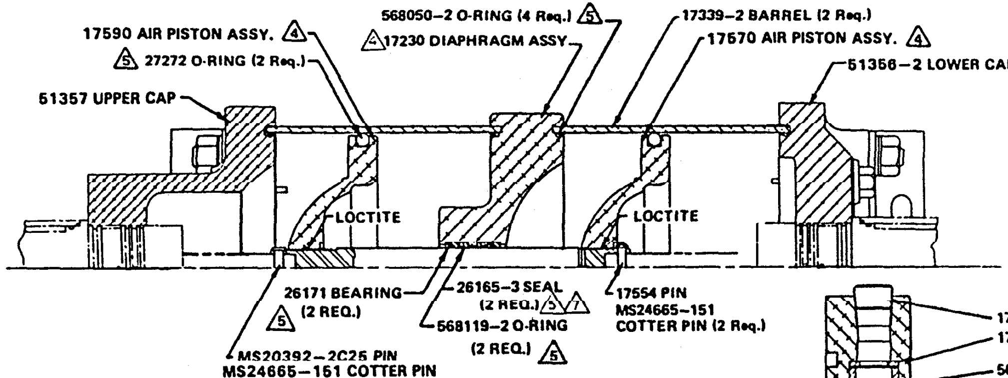
1. ALL PARTS (1) REQ. UNLESS SHOWN IN PARENTHESES.
2. FOR INSTALLATION DIMENSIONS SEE DWG. 17273
3. GAS BARREL TIE ROD TORQUE = 15 FT. LBS.
4. AIR DRIVE BOLT TORQUE = 25 FT. LBS.
5. SEE SHEET TWO OF THREE.

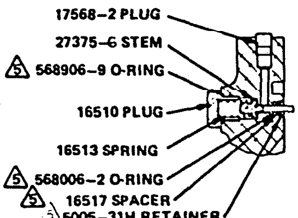
PARTS LIST
AGT - 62/152

17267

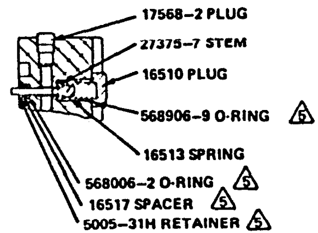
Sheet 1 of 3

REVISION G 3/79

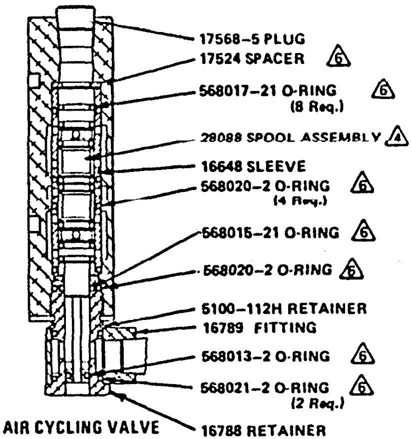




PILOT VALVE
UPPER END CAP



PILOT VALVE
LOWER END CAP



AIR CYCLING VALVE

7. ALL C-FILLED TFE SEALS SHOULD BE ASSEMBLED DRY. DO NOT LUBRICATE.
6. "AIR CYCLING VALVE" SEALS KIT, PART NO. 17329, INCLUDES SEALS IDENTIFIED BY 6 PLUS A TUBE OF HASKEL LUBE, PART NO. 28442.
5. "AIR DRIVE" SEALS KIT, PART NO. 51545-3, INCLUDES SEALS IDENTIFIED BY 5 SEE SHEET 1 OF 3.
4. PISTON ASSEMBLIES AND SPOOL ASSEMBLY ARE NON-SEPARABLE ASSEMBLIES. SEPARATE PARTS OF THESE ASSEMBLIES ARE NOT OBTAINABLE.
3. LUBRICATE AIR CYCLING VALVE AIR DRIVE BARREL(S) AND SEALS WITH HASKEL SILICONE LUBE, PART NO. 28442.
2.

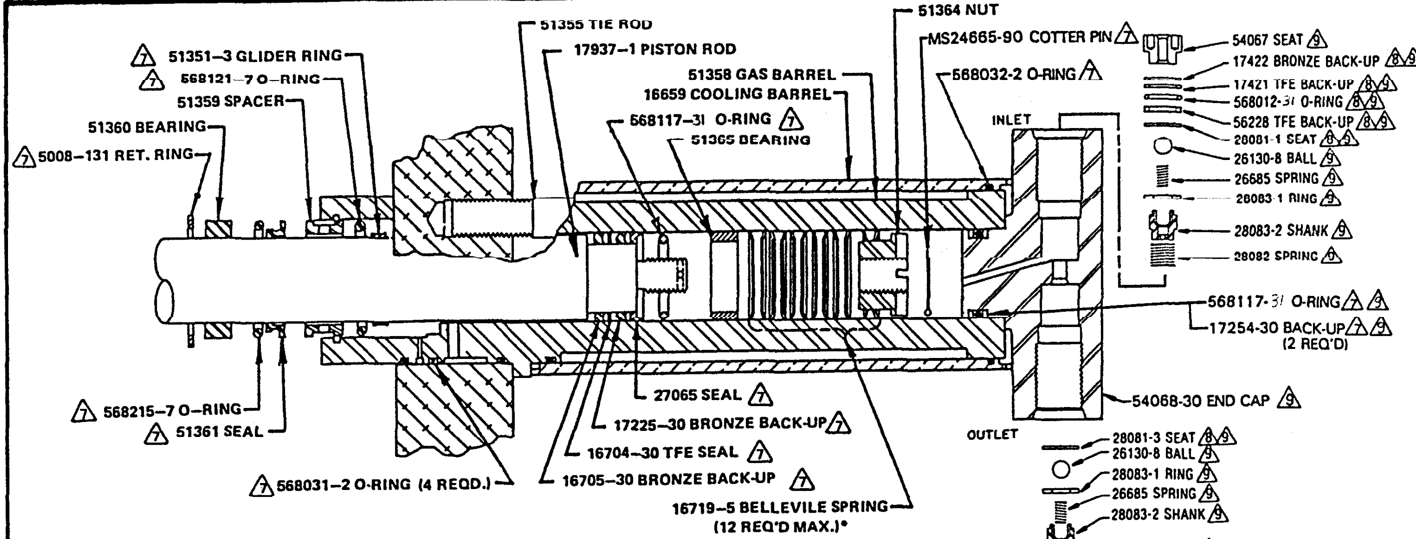
1. ALL PARTS (1) REQUIRED UNLESS SHOWN IN PARENTHESIS.

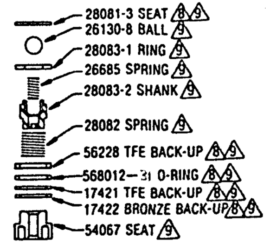
NOTES:

AIR DRIVE

AGD-32 AGD-152H AGT-62/152H
AGD-62 AGT-32/62 AGT-32/152
AGD-152 AGT-62/152 AGT-32/152H

Sheet 2 of 3
Revision L 10/93





ASSEMBLY PROCEDURE FOR GAS PISTON: (Use 17246 Assembly Tool)

WITH PISTON ROD HELD SECURELY AND EXTENDING 1/4" BEYOND THE END OF THE GAS BARREL, ASSEMBLE THE PARTS IN THE ORDER SHOWN USING THE FLAT END OF THE ASSEMBLY TOOL TO COMPACT THE SEALS. BE SURE THAT THE BELLEVILLE SPRINGS ARE ASSEMBLED IN SETS OF TWO, CUPPED ALTERNATIVELY IN OPPOSITE DIRECTIONS. USE THE OTHER END OF ASSEMBLY TOOL TO TORQUE THE NUT DOWN UNTIL SNUG AND THEN BACK OFF UNTIL A SLOT IN THE NUT LINES UP WITH THE HOLE IN THE ROD. INSERT AND SECURE THE COTTER PIN.

*NOTE: WHEN PROPERLY TIGHTENED, THE 51364 NUT SHOULD SOLIDLY CONTACT THE 17937—1 ROD SHOULDER AND BE APPROXIMATELY FLUSH WITH THE ROD END. (IF NECESSARY, USE FEWER 16719—5 SPRINGS TO ACHIEVE THIS.)

ASSEMBLY PROCEDURE FOR GAS CHECK VALVES: (Use 16675 Assembly Tool)

1. PLACE OUTLET PORT IN THE UPRIGHT POSITION. INSERT SEAT, BALL, RING, SMALL SPRING, SHANK AND LARGE SPRING UNTIL SEATED PROPERLY. IT IS IMPORTANT THAT THESE PARTS ARE IN PROPER POSITION BEFORE CONTINUING. SLIDE ONE SET OF PACKINGS (BRONZE, THIN TFE BACK-UP, O-RING, THICK TFE BACK-UP) IN THE ORDER SHOWN ONTO SEAT FITTING THE THICK TFE BACK-UP WILL PROVIDE SUFFICIENT GRIP TO RETAIN THE PACKINGS DURING INSERTION. THEN, USING ASSEMBLY TOOL, SCREW SEAT IN UNTIL IT IS SNUG (APPROXIMATELY 5/8" BELOW END CAP FACE). USING A THIN ROD, DEPRESS BALL THROUGH INLET PORT TO VERIFY PROPER MOVEMENT.

2. PLACE INLET PORT IN UPRIGHT POSITION. INSERT LARGE SPRING, SHANK, RING, SMALL SPRING, BALL AND SEAT INTO PORT UNTIL SEATED. IT IS IMPORTANT THAT THE PARTS ARE IN PROPER POSITION BEFORE CONTINUING. SLIDE ONE SET OF PACKINGS (BRONZE, THIN TFE BACK-UP, O-RING, THICK TFE BACK-UP) IN THE ORDER SHOWN ONTO SEAT FITTING. THE THICK TFE BACK-UP WILL PROVIDE SUFFICIENT GRIP TO RETAIN THE PACKINGS DURING INSERTION. THEN, USING THE ASSEMBLY TOOL, SCREW THE SEAT IN UNTIL IT IS SNUG (APPROXIMATELY 5/8" BELOW END FACE). CHECK THAT THE BALL IS FREE TO MOVE BY DEPRESSING IT WITH A THIN ROD FROM THE INLET END.

8 INDICATES PARTS IN SEALS KIT 17325

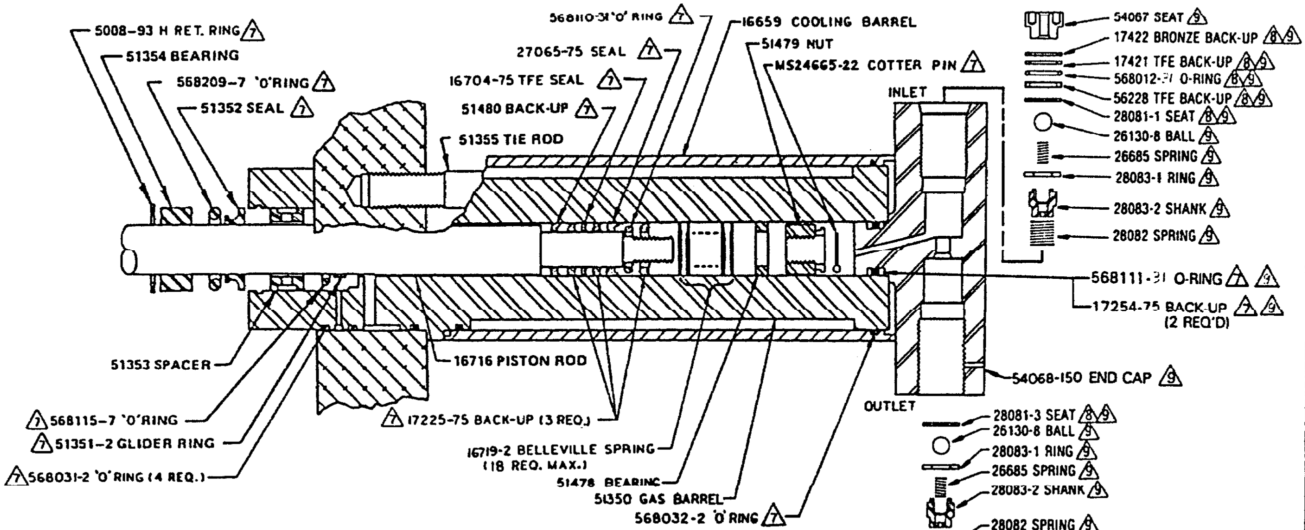
7 INDICATES PARTS IN SEALS KIT 51544–30

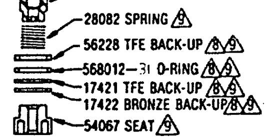
9 INDICATES PARTS IN END CAP ASSEMBLY 53632-30

REV	DESCRIPTION	DATE	DISP	BY	APPD
P	REMOVED [illegible] FROM 17325. ECO 7356	[illegible]		[illegible]	[illegible]
N	REMOVED [illegible] & 17254-30 FROM 17325-30 SEAL KIT. ECO 6156.	[illegible]	2	WLF	[illegible]
M	568012-31 WAS 568012-22. 568117-31 WAS 568117-22. ECO 5485-1.	[illegible]	2	WLF	[illegible]
L	568117-31 WAS 568117-22 SEE ECN 1966-3	[illegible]	2	JF	[illegible]

—30 GAS BARREL

SHEET 3 OF 3





ASSEMBLY PROCEDURE FOR GAS PISTON: (Use 17245 Assembly Tool)

WITH PISTON ROD HELD SECURELY AND EXTENDING 1/4" BEYOND THE END OF THE GAS BARREL, ASSEMBLE THE PARTS IN THE ORDER SHOWN USING THE FLAT END OF THE ASSEMBLY TOOL TO COMPACT THE SEALS. BE SURE THAT THE BELLEVILLE SPRINGS ARE ASSEMBLED IN SETS OF TWO, CUPPED ALTERNATIVELY IN OPPOSITE DIRECTIONS. USE THE OTHER END OF ASSEMBLY TOOL TO TORQUE THE NUT DOWN UNTIL SNUG AND THEN BACK OFF UNTIL A SLOT IN THE NUT LINES UP WITH THE HOLE IN THE ROD. INSERT AND SECURE THE COTTER PIN.

*CAUTION: MAKE SURE NUT (51479) SURFACE DOES NOT PROTRUDE BEYOND END OF ROD (16716). THIS CAN BE ACHIEVED BY USING FEWER NUMBER OF BELLEVILLE SPRINGS(16719—2) IF NECESSARY.

ASSEMBLY PROCEDURE FOR GAS CHECK VALVES: (Use 16675 Assembly Tool)

1. PLACE OUTLET PORT IN THE UPRIGHT POSITION. INSERT SEAT, BALL, RING , SMALL SPRING, SHANK AND LARGE SPRING UNTIL SEATED PROPERLY. IT IS IMPORTANT THAT THESE PARTS ARE IN PROPER POSITION BEFORE CONTINUING. SLIDE ONE SET OF PACKINGS (BRONZE, THIN TFE BACK-UP, O-RING, THICK TFE BACK-UP) IN THE ORDER SHOWN ONTO SEAT FITTING THE THICK TFE BACK-UP WILL PROVIDE SUFFICIENT GRIP TO RETAIN THE PACKINGS DURING INSERTION. THEN, USING ASSEMBLY TOOL, SCREW SEAT IN UNTIL IT IS SNUG (APPROXIMATELY 5/8" BELOW END CAP FACE). USING A THIN ROD, DEPRESS BALL THROUGH INLET PORT TO VERIFY PROPER MOVEMENT.

2. PLACE INLET PORT IN UPRIGHT POSITION. INSERT LARGE SPRING, SHANK, RING, SMALL SPRING, BALL AND SEAT INTO PORT UNTIL SEATED. IT IS IMPORTANT THAT THE PARTS ARE IN PROPER POSITION BEFORE CONTINUING. SLIDE ONE SET OF PACKINGS (BRONZE, THIN TFE BACK-UP, O-RING, THICK TFE BACK-UP) IN THE ORDER SHOWN ONTO SEAT FITTING. THE THICK TFE BACK-UP WILL PROVIDE SUFFICIENT GRIP TO RETAIN THE PACKINGS DURING INSERTION. THEN, USING THE ASSEMBLY TOOL, SCREW THE SEAT IN UNTIL IT IS SNUG (APPROXIMATELY 5/8" BELOW END FACE). CHECK THAT THE BALL IS FREE TO MOVE BY DEPRESSING IT WITH A THIN ROD FROM THE INLET END.

7 INDICATES PARTS IN SEALS KIT 55031-75

8 INDICATES PARTS IN SEALS KIT 17325

9 INDICATES PARTS IN END CAP ASSEMBLY 63632-150

REV	DESCRIPTION	DATE	USP	BY	APPD
N	REMOVED DASH NUMBER FROM 17325. ECO 1359	[illegible]		MA	[illegible]
M	REMOVED 568111-31 [illegible] FROM 17325-75 [illegible] ECO 6156.	[illegible]	2	[illegible]	[illegible]
L	568111-31 WAS 568111-22, 568012-31 WAS 568012-22 [illegible]	[illegible]	2	[illegible]	[illegible]
K	16719-2 QTY 18 WAS 24 SEE ECO	7-25-94		JF	[illegible]
J	568110-31 WAS 568110-7 SEE ECN 1466-5	2-9-94	2	JF	[illegible]

SHEET 3 OF 3

—152 GAS BARREL